

Work Order ID 130517

Friday, March 13, 2015 12:56:24 PM

130517

Page 1

Item ID: D4542-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Retainer, Inner

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLSDate: 1503-13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4542	F

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg

Prog rev: FDwg rev: F

Verify material for damage and grain direction

2- Deburr

80215/03/216061.032

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

80215/03/21

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Page 2

Item ID: D4542-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Inner

Start Date: 3/13/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

38

9-89

MAR 23 2015

125

Chemical Conversion Coat per QSI005 4.1

0.00

125

HandFinish

Memo

0.00

Hand Finishing

8

15-3-23266

127

QC7-Inspect Chemical Conversion Coat

0.00

127

QC

Memo

0.00

Quality Control

DAS

38

9-89

MAR 23 2015

Picklist Print

Friday, March 13, 2015 12:56:29 PM

Page 1

Work Order ID: 130517

130517

Parent Item: D4542-7

D4542-7

Parent Item Name: Retainer, Inner

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg reva DD verf:EC IPP REV:C 12.05.08 as
per dwg revB DD verf:EC IPP REV:D 12.08.08 AS PER DWG
REV.C DD VERF:EC IPP REV:E 13.04.23 as per dwg revD DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No				sf	249.5213		2			

M6061T6S 0.32

6061-T6 Sheet 0.032"

**

02/15/03/21

Location

Loc Qty

Loc Code

MAT021

249.5213

m130387

61.6667

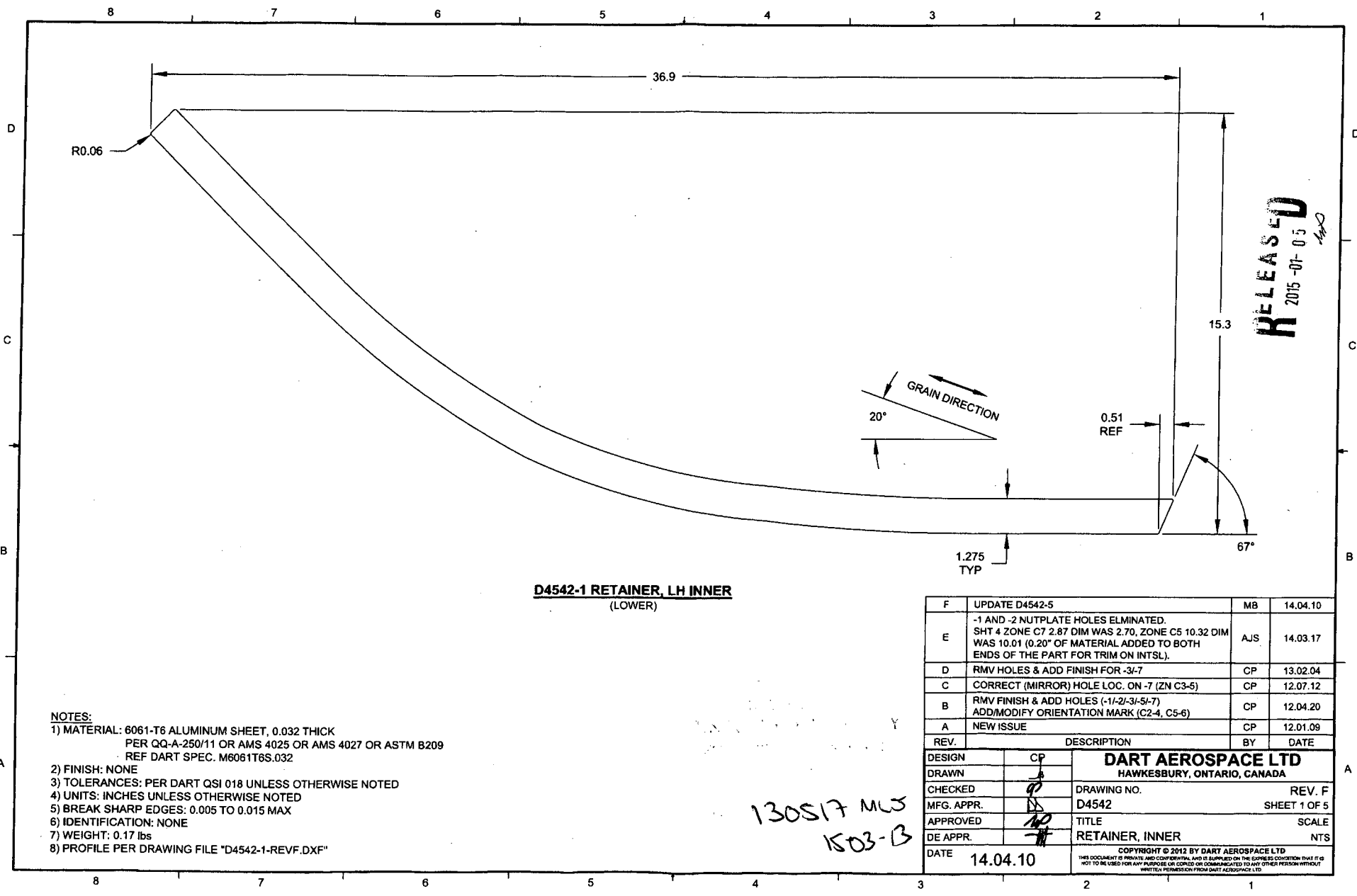
m130585

58.4546

m131352

129.4

2



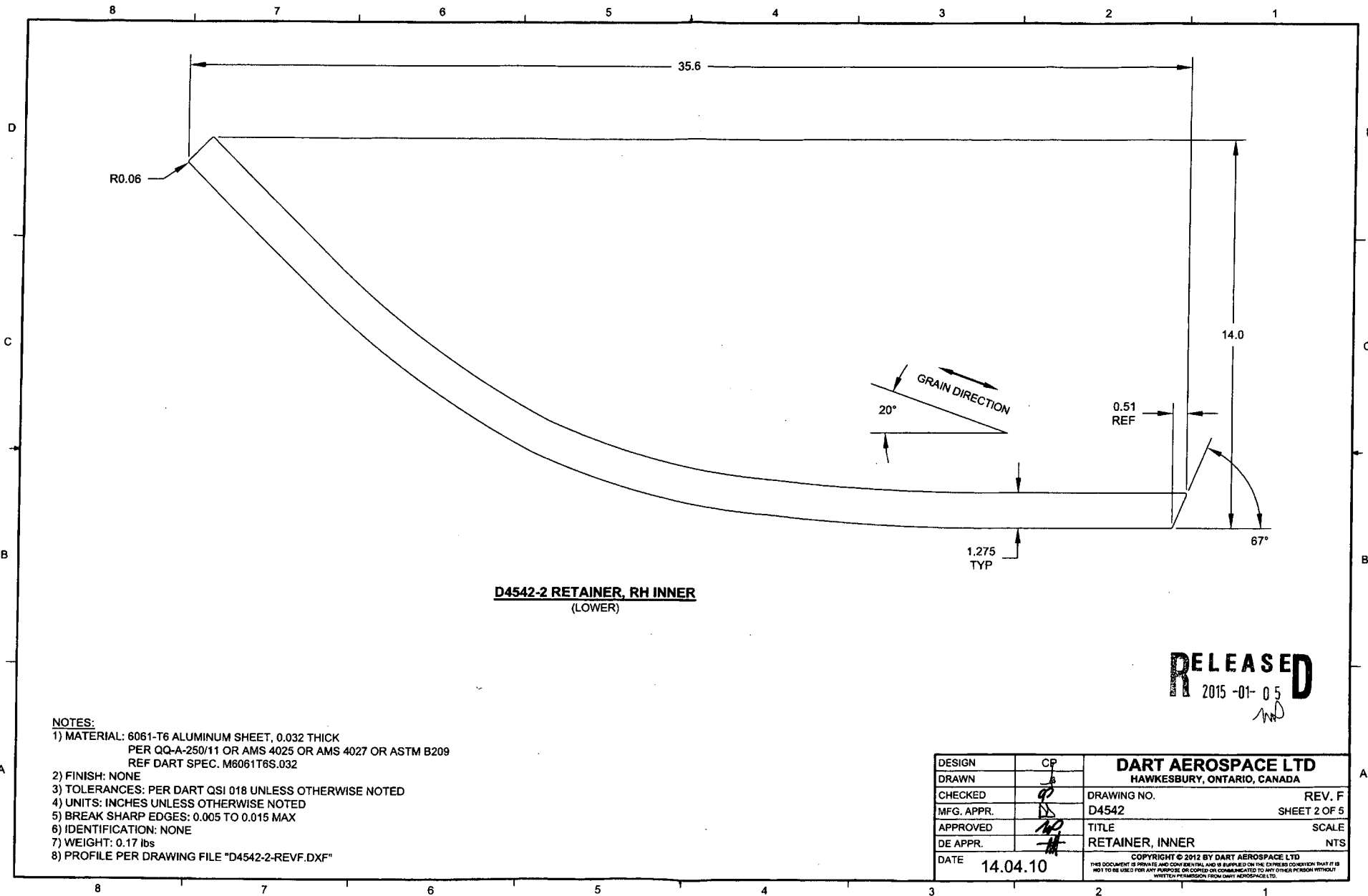
RELEASED
2015-01-05
MJD

D4542-1 RETAINER, LH INNER
(LOWER)

- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.17 lbs
 - 8) PROFILE PER DRAWING FILE "D4542-1-REV.F.DXF"

130517 MJS
1503-13

F	UPDATE D4542-5	MB	14.04.10
E	-1 AND -2 NUTPLATE HOLES ELIMINATED. SHT 4 ZONE C7 2.87 DIM WAS 2.70, ZONE C5 10.32 DIM WAS 10.01 (0.20° OF MATERIAL ADDED TO BOTH ENDS OF THE PART FOR TRIM ON INTSL).	AJS	14.03.17
D	RMV HOLES & ADD FINISH FOR -3/-7	CP	13.02.04
C	CORRECT (MIRROR) HOLE LOC. ON -7 (ZN C3-5)	CP	12.07.12
B	RMV FINISH & ADD HOLES (-1/-2/-3/-5/-7) ADD/MODIFY ORIENTATION MARK (C2-4, C5-6)	CP	12.04.20
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D4542	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	14.04.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

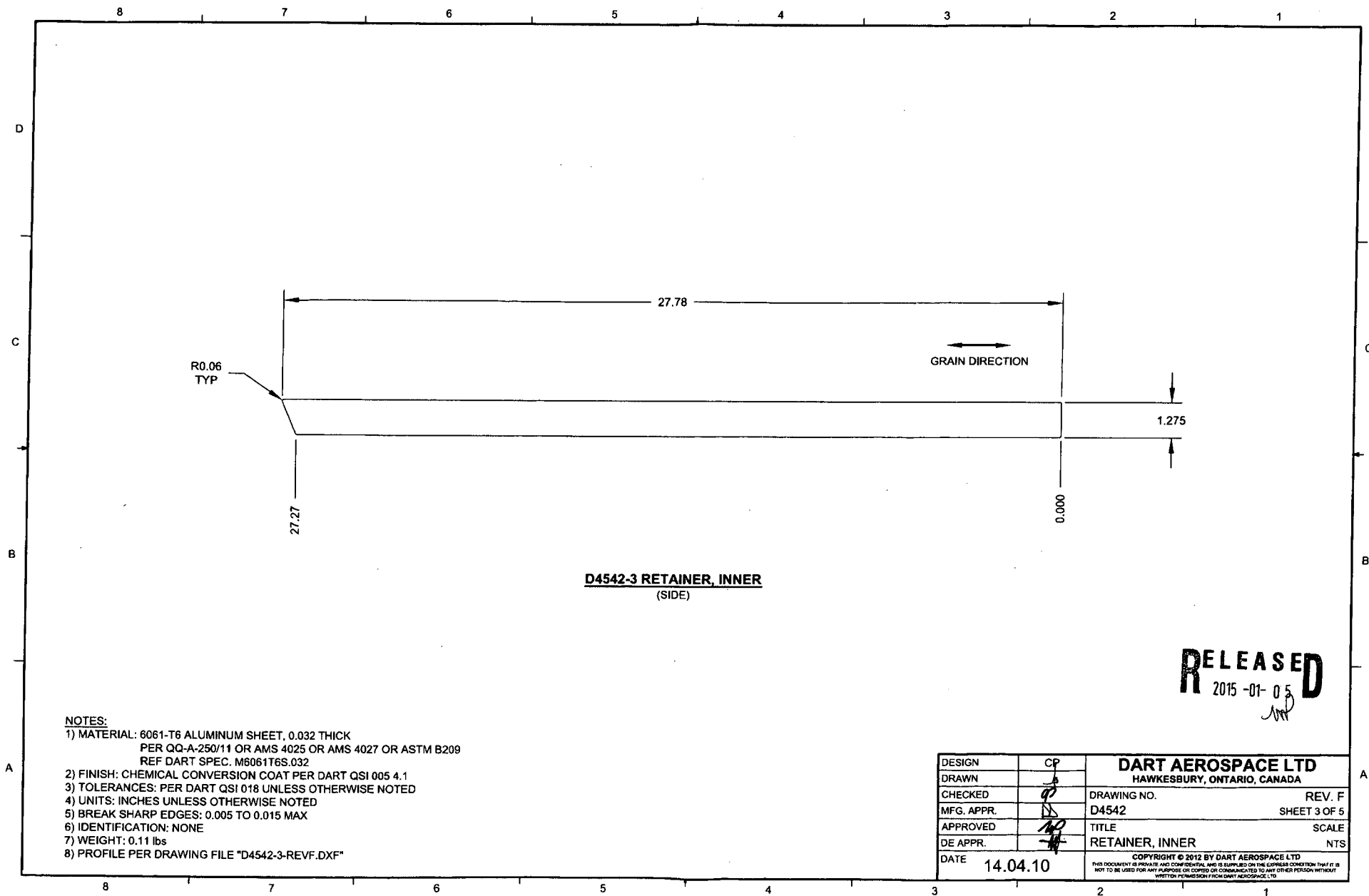


NOTES:

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PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-2-REV.F.DXF"

DESIGN	CP	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. F
MFG. APPR.	DS	D4542	SHEET 2 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.	#	RETAINER, INNER	NTS
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2015-01-05
MND



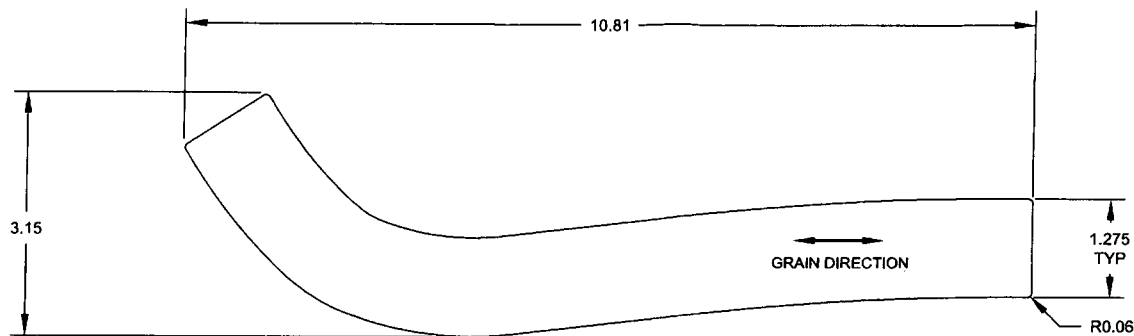
D4542-3 RETAINER, INNER
(SIDE)

RELEASED
2015-01-05

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.11 lbs
- 8) PROFILE PER DRAWING FILE "D4542-3-REV.F.DXF"

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D4542	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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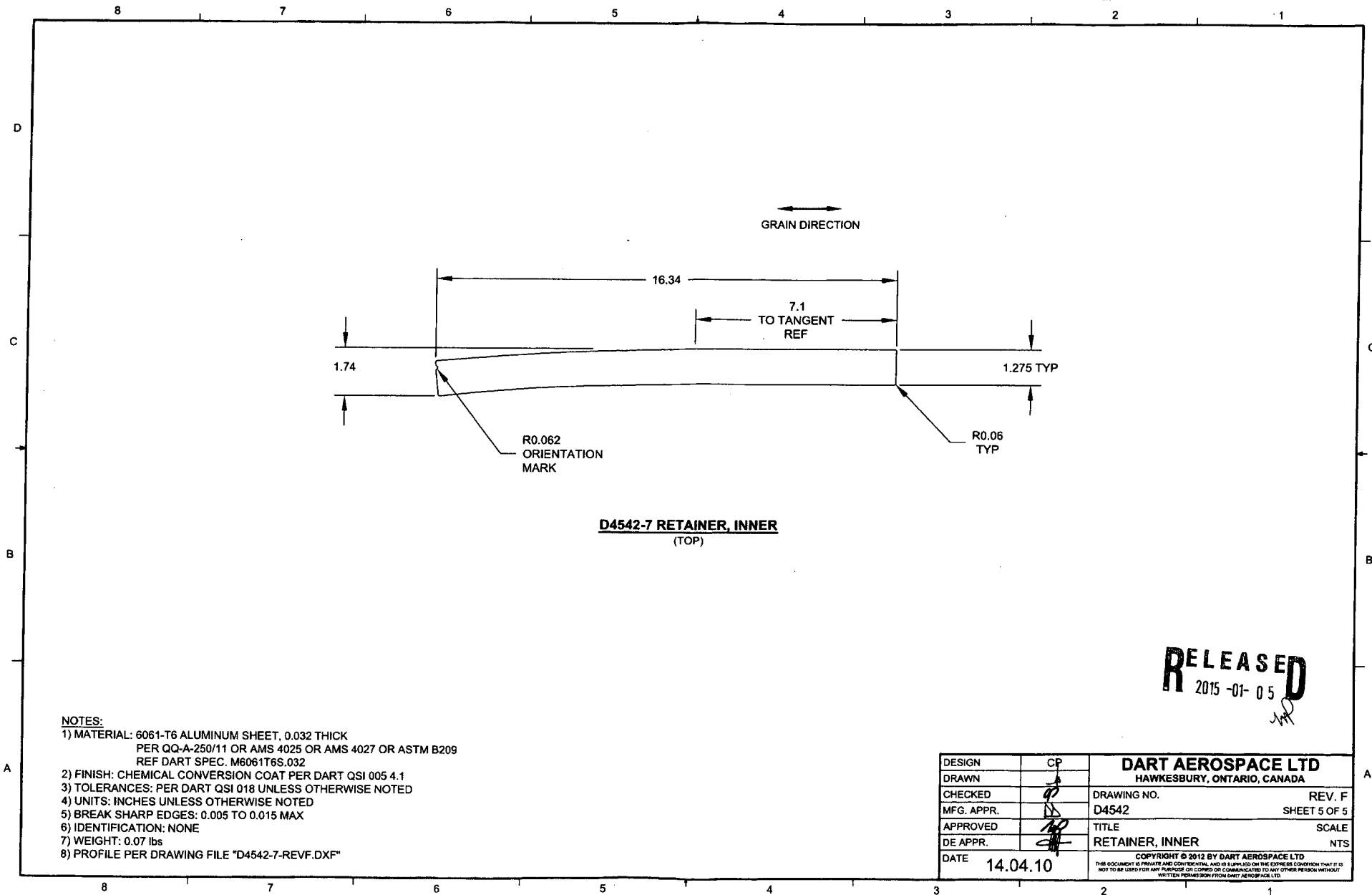
D4542-5 RETAINER, INNER
(TOP CORNER)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REV.F.DXF"

RELEASED
2015-01-05
JMT

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. F
MFG. APPR.	JS	D4542	SHEET 4 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	RETAINER, INNER	NTS
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NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
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REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs
- 8) PROFILE PER DRAWING FILE "D4542-7-REV.F.DXF"

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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